

Work Order ID 136754

136754

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September 03, 2015 3:14:29 PM

Item ID: D350-561-141 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Single Mirror Installation RH
 Start Date: 9/3/2015 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 9/29/2015 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: SA **20150904** Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev N/A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D350-561-141	CHG003							
105	Pick Kit	0.00							
105									
Packaging	Memo	0.00							
Packaging									
110	QC4- 100% Inspect kits for completeness	0.00							
110									
QC	Memo	0.00							
Quality Control									

MCS 15-09-30
 OCT 06 2015

2X BAS 27 9-89
 SEP 30 2015
 OCT 06 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

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Item ID: D350-561-141

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Single Mirror Installation RH

Start Date: 9/3/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 9/29/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Packaging	0.00							DAS 02 9-89
120									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-561-141 LOCATION: FG011								OCT 06 2015
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

ML5 OCT 06 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 136754

136754

Parent Item: D350-561-141

D350-561-141

Parent Item Name: Single Mirror Installation RH

Start Date: 9/3/2015

Required Date: 9/29/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP A 07.07.26 new issue (DSI9379) EC verified by:JLM IPP rev
B 10.02.16 per ecn 10-523 EC verified by: DD IPP Rev:C add pick kit
DD 10.03.15 verified by:EC IPP Rev:D 10.09.14 per IIN revD
DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2011-101 *D2011-101* Mirror 6"		Manufactured	No			105	Each	36.0000	1	2		DAS 27 9-89	
	DAS 02 9-89			<u>Location</u>			<u>Loc Qty</u>						
				FG			2						
				106348			2						
				ST384			34						
				122000			16						
				135152			18						
D2012-105 *D2012-105* Arm (31.06)		Manufactured	No			105	Each	9.0000	1	2		DAS 27 9-89	
	DAS 02 9-89			<u>Location</u>			<u>Loc Qty</u>						
				st376			9						
				135301			9						
D2012-107 *D2012-107* Clevis		Manufactured	No			105	Each	20.0000	1	2		DAS 27 9-89	
	DAS 02 9-89			<u>Location</u>			<u>Loc Qty</u>						
				WA004			20						
				127296			12						
				133894			8						

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Work Order ID: 136754

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Parent Item: D350-561-141

D350-561-141

Parent Item Name: Single Mirror Installation RH

Start Date: 9/3/2015

Required Date: 9/29/2015

Start Qty: 2.00

Required Qty: 2.00

D2012-111

Manufactured No

105 Each 26.0000 1 2

D2012-111
Bracket
DAS 02 9-89

**

DAS 27 9-89

Location

Loc Qty

Loc Code

ST001

26

112972

26

D2012-115

Manufactured No

105 Each 1.0000 1 2

D2012-115
Bracket, Clevis
DAS 02 9-89

**

DAS 27 9-89

Location

Loc Qty

Loc Code

ST001

1

114367

1

D2022-101

Manufactured No

105 Each 158.0000 2 4

D2022-101
Spacer
DAS 02 9-89

**

DAS 27 9-89

Location

Loc Qty

Loc Code

ST001

68

107903

68

ST012a

90

132703

90

D3629-1

Manufactured No

105 Each 6.0000 1 2

D3629-1
Bracket
DAS 02 9-89

**

DAS 27 9-89

Location

Loc Qty

Loc Code

ST047

6

113674

6

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Parent Item: D350-561-141

D350-561-141

Parent Item Name: Single Mirror Installation RH

Start Date: 9/3/2015

Required Date: 9/29/2015

Start Qty: 2.00

Required Qty: 2.00

D3635-1 Manufactured No

105 Each 10.0000 1 2

D3635-1
Gasket
DAS
02
9-89

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST047

10

94552

10

D3646-1 Manufactured No

105 Each 7.0000 1 2

D3646-1
Arm
DAS
02
9-89

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST377

7

119682

7

D3646-3 Manufactured No

105 Each 9.0000 1 2

D3646-3
Arm
DAS
02
9-89

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST377

9

113496

3

127686

1

131957

2

135599

3

D4070-041 Manufactured No

105 Each 15.0000 2 4

D4070-041
Clamp
DAS
02
9-89

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST085

15

124340

15

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Parent Item: D350-561-141

Parent Item Name: Single Mirror Installation RH

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D350-561-141

Start Date: 9/3/2015

Required Date: 9/29/2015

Start Qty: 2.00

Required Qty: 2.00

AN3-5A Purchased No 105 Each 194.0000 6 12

AN3-5A

Bolt

DAS
02
9-89

**

Location

Loc Qty

Loc Code

CA 132
m129682 132
GA 62
m131420 62

m133234

DAS
27
9-89

AN3-6A Purchased No 105 Each 162.0000 1 2

AN3-6A

Bolt

DAS
02
9-89

**

Location

Loc Qty

Loc Code

ST338a 100
M131305 100
ST349 62
M133064 62

DAS
27
9-89

AN4-5A Purchased No 105 Each 174.0000 3 6

AN4-5A

BOLT

DAS
02
9-89

**

Location

Loc Qty

Loc Code

CA 55
m129682 55
ST325A 50
m133064 50
ST345 69
120562 4
6651 1
m132317 64

DAS
27
9-89

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Work Order ID: 136754

136754

Parent Item: D350-561-141

D350-561-141

Parent Item Name: Single Mirror Installation RH

Start Date: 9/3/2015

Required Date: 9/29/2015

Start Qty: 2.00

Required Qty: 2.00

AN4-10A

Purchased

No

105

Each

43.0000

1

2

AN4-10A

Bolt

DAS
02
9-89

**

DAS
27
9-89

Location

Loc Qty

Loc Code

CA

17

M129682

17

ST345

26

131677

26

NAS1149D0363J

Purchased

No

105

Each

1,539.000

8

16

NAS1149D0363.J

Washer

DAS
02
9-89

**

DAS
27
9-89
SEP 30 2015

Location

Loc Qty

Loc Code

CA

246

m130799

246

GA

256

m130799

256

ST269

1037

m126319

7

m131618

1

m132317

10

m132677

50

m133031

969

16

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Work Order ID: 136754

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Parent Item: D350-561-141

D350-561-141

Parent Item Name: Single Mirror Installation RH

Start Date: 9/3/2015

Required Date: 9/29/2015

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0463J

Purchased

No

105

Each

3,126.000

8

16

NAS1149D0463J

WASHER

DAS

27

9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

GA

41

M129390

41

ST260a

1000

M133077

1000

ST269

2085

M129682

86

M130799

371

~~M12285~~

615

M132317

125

M132677

888

46

x16

MS21042L3

Purchased

No

105

Each

742.0000

4

8

MS21042L3

Nut

DAS
02
9-89

DAS

27

9-89

Location

Loc Qty

Loc Code

FP001

370

M130922

370

GA

225

M131317

225

ST305

147

116549

12

126333

49

M128754

2

M132123

17

M132382

2

M132883

17

M132930

48

M133134

8

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Work Order ID: 136754

136754

Parent Item: D350-561-141

D350-561-141

Parent Item Name: Single Mirror Installation RH

Start Date: 9/3/2015

Required Date: 9/29/2015

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

Purchased

No

105

Each

2,170.000

4

8

MS21042L4

Locknut

**DAS
02
9-89**

DAS

27

9-89

SEP 30 2015

Location

Loc Qty

Loc Code

FP001

2

m124231

2

GA

112

m127813

112

ST260a

170

m130799

56

m131803

6

m132262

108

ST305

1886

m128300

8

m130388

7

m130922

97

m131618

12

m132123

56

m132382

1706

8

5. PARTS LIST

Qty -041	Qty -043	Qty -045	Qty -141	Qty -143	Qty -241	Qty -243	Part Number	Description
X	1						D350-561-041	SINGLE MIRROR INSTALLATION, RH
	X						D350-561-043	DUAL MIRROR INSTALLATION, RH
	1	X		1		1	D350-561-045	MIRROR KIT
			X	1			D350-561-141	SINGLE MIRROR INSTALLATION, RH
				X			D350-561-143	DUAL MIRROR INSTALLATION, RH
					X	1	D350-561-241	SINGLE MIRROR INSTALLATION, LH
						X	D350-561-243	DUAL MIRROR INSTALLATION, LH
1		1	1		1		D2011-101	Mirror
1							D2012-101	Arm
1							D2012-103	Arm
1			1				D2012-105	Arm
					1		D2012-106	Arm
2			1		1		D2012-107	Clevis
1							D2012-109	Bracket
1			1		1		D2012-111	Bracket
4		2					D2012-113	Clamp
1			1		1		D2012-115	Bracket
4			2		2		D2022-101	Spacer
4							D2856-100-325	Abrasion Strip
1*		1*	1*		1*		D3014-1	Locknut
			1		1		D3629-1	Bracket
			1		1		D3635-1	Gasket
		2					D3635-3	Gasket
			1				D3646-1	Arm
					1		D3646-2	Arm
			1				D3646-3	Arm
					1		D3646-4	Arm
			2		2		D4070-041	Clamp
2							AN3-4A	Bolt
2		2	6		6		AN3-5A	Bolt
1			1		1		AN3-6A	Bolt
2			1		1		AN4-10A	Bolt
3			3		3		AN4-5A	Bolt
14		4	8		8		AN960JD10	Washer
9		2	8		8		AN960JD416	Washer
1*		1*	1*		1*		AN960JD416L	Washer
5		2	4		4		MS21042L3	Nut (or MS21042-3)
5			4		4		MS21042L4	Nut (or MS21042-4)

*INCLUDED AS PART OF D2011-101 MIRROR